

shp Dec 22

Work Order ID 76034

76034

Page 1

November-03-11 10:39:07 AM

Item ID: D350-591-311 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step, Long LH
 Start Date: 03/11/2011 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 15/12/2011 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: M.L.S Date: 11/11/03 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-311 CHG001								
110	Large Fab	0.00							
110									
Large Fab	Memo	0.00							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod 114514								
	118735								
	3-Grind End Plate flush								

11-11-24 (5)
 JG for M.L.S 11-11-24 (5)

11-11-16

5 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76034

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

5

Cust Item ID:

5

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0,00

130

OC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 76034

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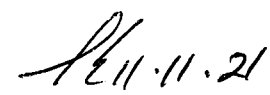

November-03-11 10:39:07 AM

Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step, Long LH
 Start Date: 03/11/2011 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 15/12/2011 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod 114514								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

5 BR 11-11-17

5  

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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November-03-11 10:39:07 AM

Item ID: D350-591-311

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop ***NS2***

Start Date: 03/11/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 15/12/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

220

Powdercoat

Powder Coating

Memo

START TIME: 1:30

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:00

0.00

SXJ M-L W/M 23
LH

230 Wing Walk as per dwg QSI005 4.4 Batch 118988 0.00

230

HandFinish

Hand Finishing

Memo

0.00

5 BL 11-11-23.

240 QC3- Inspect Part Finish 0.00

240

QC

Quality Control

Memo

0.00

11-11-23 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 76034***76034***

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November-03-11 10:39:07 AM

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Long LH

Start Date: 03/11/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 15/12/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311								
	Location: <u>WALL</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November-03-11 10:39:07 AM

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop ***NS2***

Start Date: 03/11/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 15/12/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

11/11/28 *[Signature]*
MF
11-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

November-03-11 10:39:12 AM

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Work Order ID: 76034

76034

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 03/11/2011

Required Date: 15/12/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1		Manufactured	No			110	Each	38.0000	1	5			
D3272-1													
Step													

Location	Loc Qty	Loc Code
WA <u>376041</u>	38	
74948	10	
74949	10	
74950	10	
75832	8	

D3067-1		Manufactured	No			110	Each	138.0000	1	5			
D3067-1													
End Plate													

Location	Loc Qty	Loc Code
WA	137	
67582	2	
73404	60	
<u>75468</u>	75	
WA016	1	
68214	1	

D3219-1		Manufactured	No			110	Each	130.0000	2	10			
D3219-1													
Plate													

Location	Loc Qty	Loc Code
WA	130	
<u>73410</u>	130	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November-03-11 10:39:12 AM

Work Order ID: 76034

76034

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 03/11/2011

Required Date: 15/12/2011

Start Qty: 5.00

Required Qty: 5.00

D3066-1 Manufactured No

180 Each 152.0000 2 10

D3066-1

**

@ 11.11.19

Spacer

Location

Loc Qty

Loc Code

WA

152

73409

48

75076

104

10

MS20600-AD4W4 Purchased No

180 Each 2,694.000 16 80

MS20600-AD4W4

**

11.11.21

Rivets

Location

Loc Qty

Loc Code

ST321

2689

116188

59

117364

253

117601

200

117885

195

118840

1982

20

WA018

5

116712

5

D3065-041 Manufactured No

180 Each 0.0000 1 5

D3065-041

**

11.11.21

Step Leg Assembly Hi

D3067-1 Manufactured No

180 Each 138.0000 1 5

D3067-1

**

11.11.21

End Plate

Location

Loc Qty

Loc Code

WA

137

67582

2

73404

60

75468

75

5

WA016

1

768214

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

November-03-11 10:39:12 AM

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Work Order ID: 76034

76034

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 03/11/2011

Required Date: 15/12/2011

Start Qty: 5.00

Required Qty: 5.00

AN3-35A

Purchased

No

250

Each

199.0000

2

10

8x

**

M119641

AN3-35A

Bolt

Location

Loc Qty

Loc Code

ST353

199

117619

3

117794

1

118838

95

119449

100

2

D3235-1

Manufactured

No

250

Each

136.0000

2

10

**

D3235-1

Mounting Lug

Location

Loc Qty

Loc Code

ST481

136

71965

30

73411

106

10

D3278-041

Manufactured

No

250

Each

36.0000

1

5

**

B76/70

D3278-041

Support Assembly

Location

Loc Qty

Loc Code

ST481

36

73107

36

16

80

AN960JD416

NAS1149D0463J

Purchased

No

250

Each

0.0000

**

M117897

AN960JD416

Washer

AN960JD516

NAS1149D0563J

Purchased

No

250

Each

0.0000

4

20

**

M118206 11/11/24

AN960JD516

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November-03-11 10:39:12 AM

Work Order ID: 76034

76034

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 03/11/2011

Required Date: 15/12/2011

Start Qty: 5.00

Required Qty: 5.00

AN5-36A

Purchased

No

250

Each

165.0000

2

10

**

AN5-36A

Bolt

Location

Loc Qty

Loc Code

ST340

165

118451

100

~~118838~~

15

119449

50

10

D2618

Manufactured

No

250

Each

58.0000

2

10

**

D2618

Bushing

Location

Loc Qty

Loc Code

ST019

58

73408

58

10

D2230-3

Manufactured

No

250

Each

263.0000

4

20

**

D2230-3

Lug

Location

Loc Qty

Loc Code

ST476

4

53881

4

ST480

259

70973

1

73396

138

74440

120

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 76034

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

76034

D350-591-311

Start Date: 03/11/2011

Required Date: 15/12/2011

Start Qty: 5.00

Required Qty: 5.00

D2856-400

Manufactured No

250 f

323.5945 1.2 6

D2856-400

Abraison Strip

**

Location

Loc Qty

Loc Code

ST403

0.3149

68076

0.3149

ST409

323.2796

63735

0.6696

71164

106.61

73491

216

cut (2) at 7.20" (D2856-400-720)

MS21042L3

Purchased No

250 Each

9,659.000 2 10

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

679

117441

16

117885

42

118451

55

118927

566

ST516

6000

119017

6000

ST518

2980

119075

2980

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 03/11/2011

Required Date: 15/12/2011

Start Qty: 5.00

Required Qty: 5.00

AN4-13A

Purchased

No

250

Each

1,529.000

8

40

AN4-13A

Bolt

Location

Loc Qty

Loc Code

ST357

1529

118078

521

118706

8

118838

500

119449

500

MS21042L5

Purchased

No

250

Each

2,426.000

2

10

MS21042L5

Nut

Location

Loc Qty

Loc Code

ST300

926

116105

5

116548

51

117611

74

118179

496

118910

300

ST518

1500

119109

1500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 03/11/2011

Required Date: 15/12/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

250

Each

13,123.00

8

40

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

2123

117441

51

117601

532

118451

540

118927

1000

ST516

6000

119017

6000

40

ST518

5000

119075

5000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

20

AN960JD10

Washer

**

11/11/24

sl

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76034
M-L-J
11/11/03

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

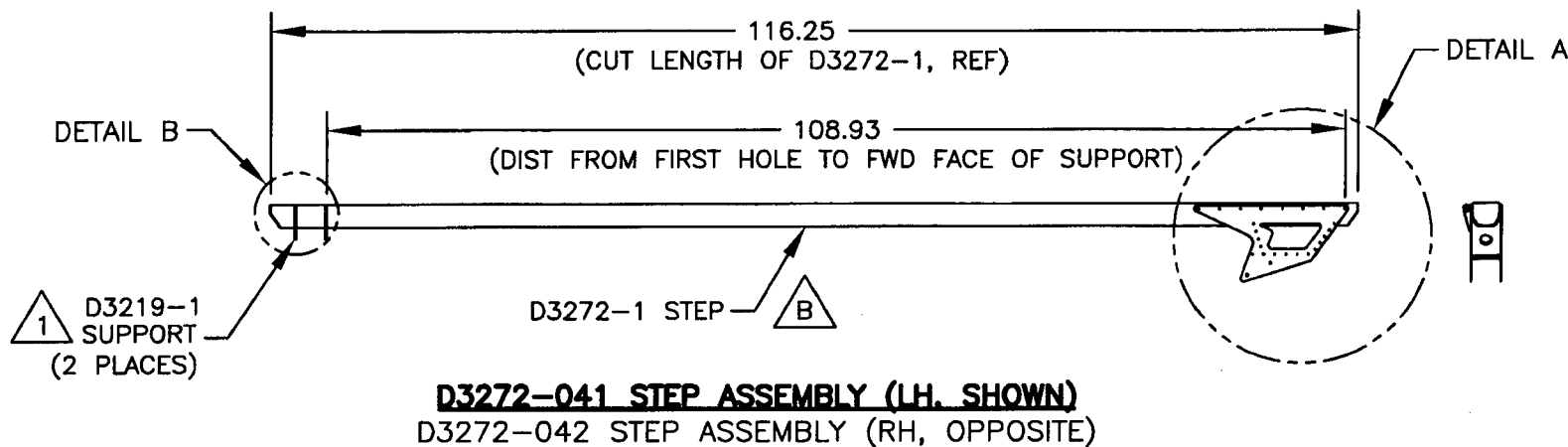
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

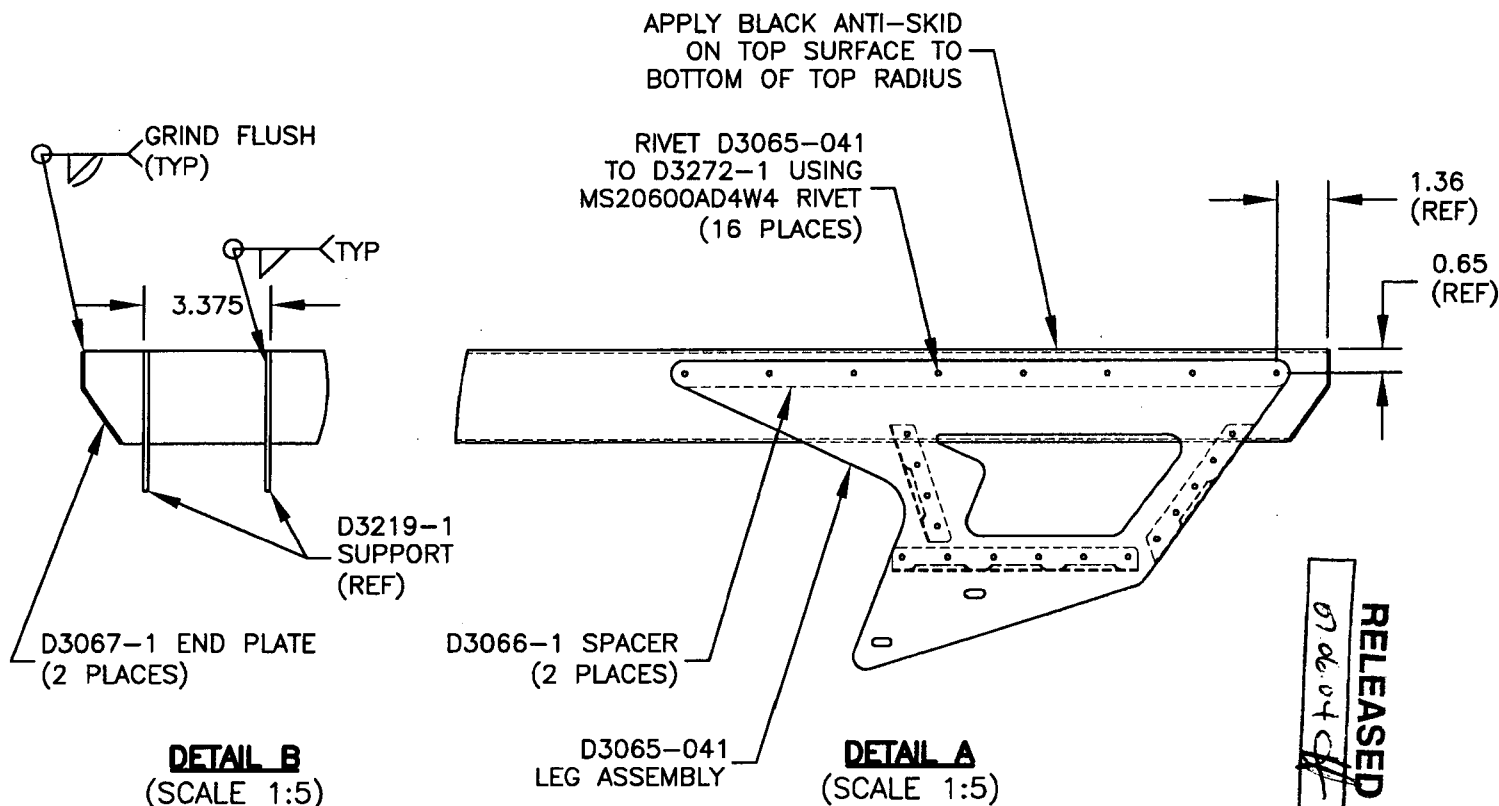


DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 3
DATE	TITLE	SCALE	
07.05.18	STEP ASSEMBLY, HI LONG	1:20	

26034



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.06.04

DETAIL B
(SCALE 1:5)

DETAIL A
(SCALE 1:5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

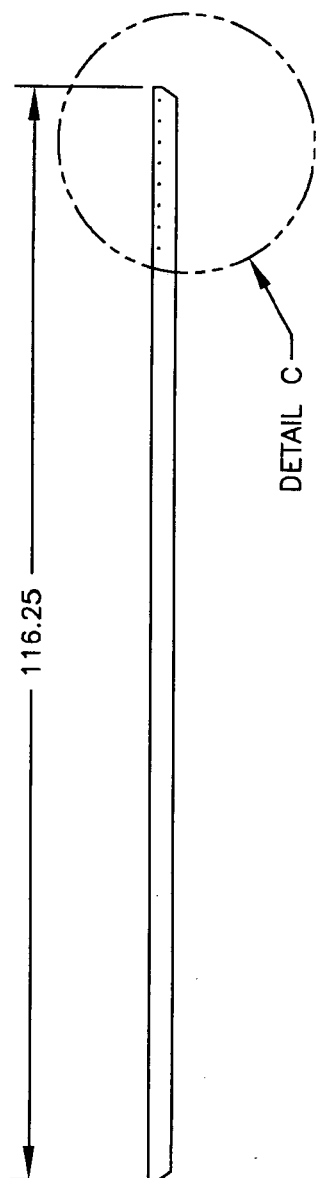
NOTE: Date & initial all entries



DESIGN 9P	DRAWN BY JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED JB	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

RELEASED

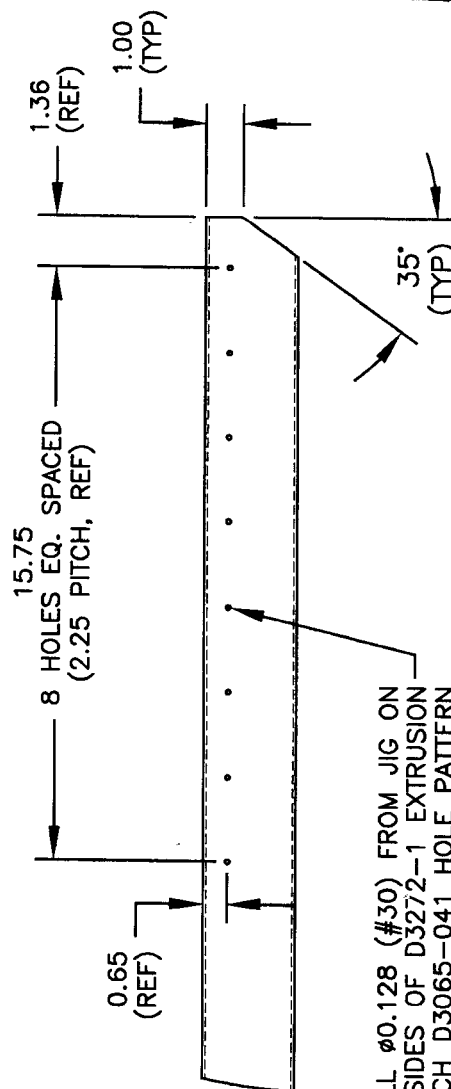
07.06.04



DETAIL C

D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.